

Work Order ID 113003

Tuesday, February 11, 2014 2:48:36 PM

113003

Page 1

Item ID: PB67-43001-253

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Gusset

Start Date: 2/11/2014 Start Qty: 24.00

24

Cust Item ID:

Required Date: 2/28/2014 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: umf Date: 14-2-11 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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B67-43001	C
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100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg B67-43001

Dwg Rev: C

Prog Rev: C

60061.125"

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

28 0 Jm14-02-16

28 0 Jm14-02-16

NCR: Yes / No

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Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other	
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	☐ Pressure/Forced
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	☐ Temperature/Cure
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	☐ Weld
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	☐ Wrong Stock Pulled
			☐ Other

NCR: Yes / No

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		☐ Power Loss/Surge
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		☐ Temperature/Cure
		☐ Weld
		☐ Wrong Stock Pulled
		☐ Other

Picklist Print

Tuesday, February 11, 2014 2:48:35 PM

Page 1

Work Order ID: 113003

Parent Item: PB67-43001-253

Start Date: 2/11/2014

Required Date: 2/28/2014

Parent Item Name: Gusset

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP rev A new issue 08.06.19 DD verified: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.125

Purchased

No

100

sf

173.5330

0.1289

4

6061-T6 .125 Sheet

Jm14-02-16

Location

Loc Qty

Loc Code

MAT021

173.533

m127272

39.5

m127454

102.033

m127501

32

127454

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

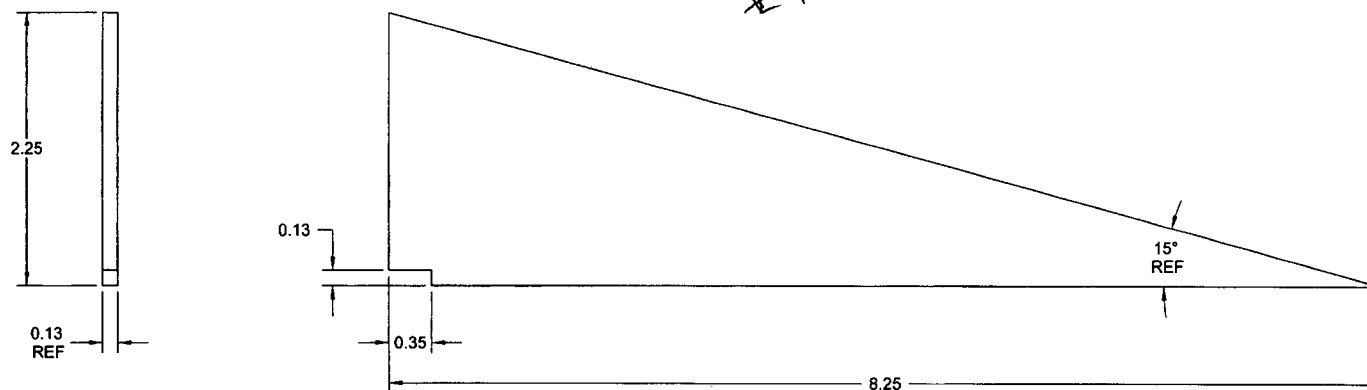
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		☐ Temperature/Cure
		☐ Weld
		☐ Wrong Stock Pulled
		☐ Other



B67-43001-253 GUSSET

RELEASED
2009-09-24
MP

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF. DART SPEC. M6061T6S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 23 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#08-011.		MB	09.03.10
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	<i>NS</i>		DRAWING NO.	REV.
MFG. APPR.	<i>MP</i>		B67-43001-253	SHEET 1 OF
APPROVED	<i>MP</i>		TITLE	SCALE
DE APPR.	N/A	GUSSET	NTS	
DATE	09.03.10	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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